

Work Order ID 130600

Tuesday, March 17, 2015 11:49:09 AM

130600

Page 1

Item ID: D3147-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Pin

Stop *NS2*

Start Date: 3/17/2015 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 3/17/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 15-03-17

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Equip/Tooling ☐									
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Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Work Order ID 130600

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Page 2

Item ID: D3147-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pin
 Start Date: 3/17/2015 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 3/17/2015 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>st 022</u>	0.00							
130									
Packaging	Memo	0.00				7	DAS 27 9-89		
Packaging									
								MAR 23 2015	
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 15-03-24
 MF
 15-3-24

DQA: _____ Date: _____



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Picklist Print

Tuesday, March 17, 2015 11:49:15 AM

Page 1

Work Order ID: 130600

130600

Parent Item: D3147-1

D3147-1

Parent Item Name: Pin

Start Date: 3/17/2015

Required Date: 3/17/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev A New Issue 07-01-26 JLM
 IPP Rev:B Now on Cnc 07-05-02 JLM
 IPP Rev:C Now on Doosan 08-10-14 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.187		Purchased	No			100	f	36.0000	0.225	2			DAS
M303R0 187									**			15/03/22	40
303 Round Bar 0.187"													2.00

Location

Loc Qty

Loc Code

MAT028

36

→ m127864

36

2.0

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DART AEROSPACE LTD		Work Order:	130600
Description: Pin		Part Number:	D3147-1
Inspection Dwg: D3147 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/-0.010	2.499	✓		VERN	Photo
0.200	+/-0.010	.204	✓		"	"
5°	+/-0.5°	5°	✓		Ang G	
R0.08	+/-0.030	.08	✓		Rad G	
R0.010	+/-0.010	.010	✓		"	
Ø0.125	+0.004/-0.001	.125	✓		VERN	Photo
0.150	+/-0.010	.155	✓		"	"
R0.09	+/-0.030	.09	✓		Rad G	
0.200	+/-0.010	.200	✓		VERN	"
Ø0.181	+/-0.010	.188	✓		"	"
0.620	+/-0.010	.622	✓		"	"
0.111	+/-0.010	.113	✓		"	"
R0.01	+/-0.030	.010	✓		Rad G	

Measured by:	40	Audited by:	DA	Prototype Approval:	N/A
Date:	15/03/22	Date:	15/03/23	Date:	N/A
Rev	Date	Change	Revised by	Approved	
A	08.09.04	New Issue	KJ/DD		

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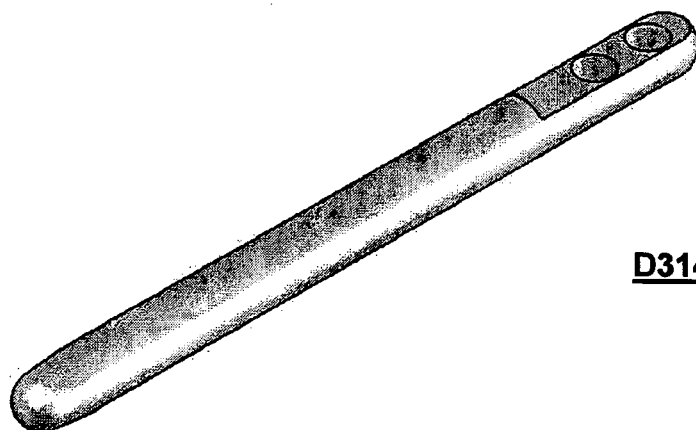
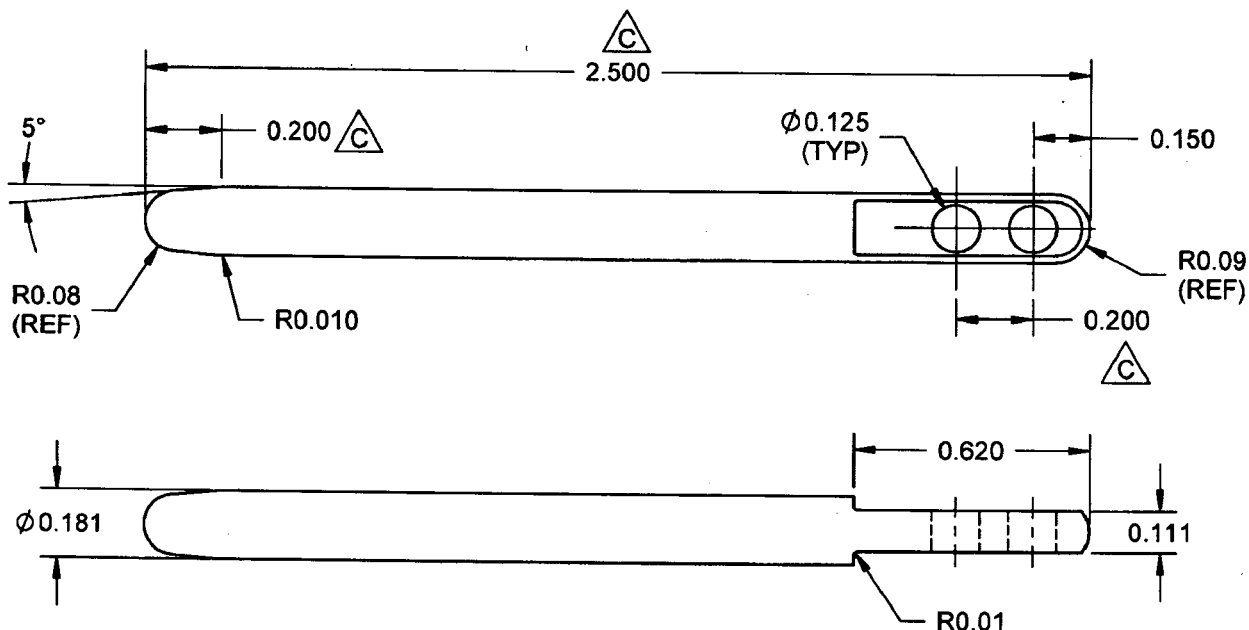
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DESIGN #	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED JH	DRAWING NO. D3147	REV. C SHEET 1 OF 1
DATE 06.12.04	TITLE PIN SCALE 2:1		
REV	DATE	DESCRIPTION	
A	02.04.23	NEW ISSUE	
B	04.10.18	ADD PART MARKING AND NORMALIZED	
C	06.12.04	ADD SECOND $\varnothing 0.125$ HOLE; CHANGE MATERIAL; 0.200 TAPER WAS 0.400; REMOVE SUPPLIER AND FINISHING	



D3147-1 PIN

130600 M.C.S
15-03-17

RELEASED

07-01-22

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF DART SPEC M303R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3147-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015 MAX
- 7) REPLACES PREMIER P/N B30-23000-119

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